

Work Order ID 163618

Tuesday, July 04, 2017 11:18:30 AM

163618

Page 1

Item ID: D206-642-311BL Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Skidtube LH (Ael Blue)
Start Date: 7/10/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 7/20/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 04 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-642	Q

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-311 CHG008								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

B#162231 x 1

AUG 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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163618

Page 2

Item ID: D206-642-311BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Skidtube LH (Ael Blue) Stop ***NS2***
Start Date: 7/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/20/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: _____ Packaging	0.00				DAS 27 9-89			
Packaging	Memo Identify and pack for shipping as per PPP D206-642-311 Location: _____ PPP Rev: _____ Sold	0.00							
140 *140* QC	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
Quality Control	Memo	0.10						AUG 2 8 2017	

DAS
21
9-89
AUG 2 8 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Page 1

Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25
 ECN14-520 DD verf:JLM IPP REV:O 15.10.09 ADDED
 BL DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	86.0000	8	8	DAS 6 9-89	JUL 26 2017	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				20					
				122416				20					
				ST347				66		138884			
				m137544				66					
AN4-6A *AN4-6A* BOLT		Purchased	No			110	Each	551.0000	12	12	DAS 6 9-89	JUL 26 2017	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST345				551					
				M137464				551		12			
AN4C5A *AN4C5A* Bolt		Purchased	No			110	Each	45.0000	1	1	DAS 6 9-89	JUL 26 2017	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FP001				38					
				m133990				38		138890			
				ST345				7					
				m137164				7					

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WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Page 2

Work Order ID: 163618

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Acl Blue)

163618

***D206-642-311RI ***

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Purchased No

110 Each 275.0000 4 4

AN5-10A

Bolt

**

DAS
6
9-89

DAS
28
9-89

JUL 26 2017

Location

Loc Qty

Loc Code

GA

29

122800

29

over003

200

m137680

50

m137886

150

ST338

46

m137544

46

AN5-11A Purchased No

110 Each 105.0000 8 8

AN5-11A

BOLT

**

DAS
6
9-89

DAS
28
9-89

JUL 26 2017

Location

Loc Qty

Loc Code

over003

100

M137710

100

ST338

5

M137507

5

AN5-12A Purchased No

110 Each 16.0000 4 4

AN5-12A

Bolt

**

DAS
6
9-89

DAS
28
9-89

JUL 26 2017

Location

Loc Qty

Loc Code

ST338

16

m137680

16

D206-642-341BL Manufactured No

110 Each 0.0000 1 1

***D206-642-341RI ***

Replacement Skidtube (LH or RH)

**

B162231

DAS
28
9-89

D206-648-013BL Manufactured No

110 Each 0.0000 1 1

***D206-648-013RI ***

Ground Handling Wheel Modification

**

B163839

DAS
28
9-89

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 110 Each 342.0000 16 16

D2652

Bushing

**

AUG 01 2017

DAS 28
DAS 89
6
9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST009	298	
161518	298	

163857

D2712 Manufactured No 110 Each 234.0000 10 10

D2712

Set Screw

**

DAS 6
9-89

AUG 06 2017

DAS 28
9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST010	184	
161464	174	
89929	10	

164000

15-168

D2932-1BL Manufactured No 110 Each 4.0000 1 1

***D2932-1RI ***

Saddle LH Out, 206

**

AUG 01 2017

DAS 28
DAS 89
6
9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
ST389	4	
161255	4	

161584

D2933-1BL Manufactured No 110 Each 16.0000 1 1

***D2933-1RI ***

Saddle LH In, 206

**

AUG 01 2017

DAS 28
DAS 89
6
9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
ST390	16	
161256	10	
161586	6	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D2934 Manufactured No

110 Each * 64.0000 2 2

D2934

Saddle Spacer

**

DAS
6
9-89

DAS
28
9-89

JUL 16 2017

DAS
27
9-89

Location Loc Qty Loc Code

FG 6

31929 6

ST014 58

161523 58

D2935 Manufactured No

110 Each 66.0000 2 2

D2935

Saddle Spacer

**

DAS
6
9-89

DAS
28
9-89

JUL 16 2017

DAS
27
9-89

Location Loc Qty Loc Code

FG 6

31793 6

ST014 60

161524 60

D2938-1BL Manufactured No

110 Each 16.0000 1 1

***D2938-1RI ***

Saddle LH Out, 206

**

DAS
6
9-89

DAS
28
9-89

AUG 01 2017

DAS
27
9-89

Location Loc Qty Loc Code

ST391 16

161257 4

161588 12

D2939-1BL Manufactured No

110 Each 18.0000 1 1

***D2939-1RI ***

Saddle LH In, 206

**

DAS
6
9-89

DAS
28
9-89

AUG 01 2017

DAS
27
9-89

Location Loc Qty Loc Code

ST392 18

161258 6

162130 12

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DQA: _____ Date: _____



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163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Acl Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D3407-043 Manufactured No

110 Each 29.0000 1 1

D3407-043

Tow Ring

**

Location	Loc Qty	Loc Code
st530	29	
153708	3	
159457	10	
161525	16	

AUG 01 2017

DAS 28
6 9-89

BLUE
D3413-1 Manufactured No

110 Each 51.0000 1 1

D3413-1

O-Ring

**

Location	Loc Qty	Loc Code
FP001	2	
145648	2	
st530	49	
153479	4	
155256	12	
159722	15	
161595	18	

AUG 01 2017

DAS 28
6 9-89

BLUE
D3456-1 Manufactured No

110 Each 121.0000 1 1

D3456-1

Washer

**

Location	Loc Qty	Loc Code
FG	6	
25701	6	
ST036	115	
159500	19	
162291	96	

DAS 28
6 9-89

JUL 26 2017

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Picklist Print

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Page 6

Work Order ID: 163618

163618

Parent Item: D206-642-311BL

D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

38.0000

2

2

D3457-1

Washer

**

DAS
6
9-89

JUL 10 2017
JUL 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST036

28

160979

28

163805

MS21042L3

Purchased No

110 Each

1,421.000

8

8

MS21042L3

Nut

**

DAS
6
9-89

JUL 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

OVER007

500

m134360

0

m137886

500

ST303

448

m137680

448

137988

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Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

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Page 7

Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

1,971.000

12

12

MS21042I 4

Nut

**

DAS
6
9-89

Required Date: 7/20/2017

Required Qty: 1.00

DAS
6
9-89

DAS
28
9-89

JUL 26 2017

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

51

m135058

51

OVER007

1400

m137402

400

m137680

1000

ST303

510

m137544

510

12

MS21043-4

Purchased

No

110

Each

750.0000

1

1

MS21043-4

Nut

**

DAS
6
9-89

DAS
28
9-89

JUL 26 2017

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

99

m132803

5

m137371

94

OVER007

300

m137886

300

ST302

311

m137361

111

m137371

200

1

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

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Page 8

Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased

No

110

Each

357.0000

1

1

NAS1149C0463R

Washer

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

25

m127306

25

ST260a

200

m137736

200

ST266

132

m136263

132

JUL 26 2017

DAS
28
9-89

NAS1149D0363J

Purchased

No

110

Each

647.0000

8

8

NAS1149D0363J

Washer

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

43

m134055

13

m137164

30

ST263

604

m137587

604

JUL 26 2017

DAS
28
9-89

NAS1149D0463J

Purchased

No

110

Each

3,453.000

25

25

NAS1149D0463J

Washer

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

40

M135056

40

ST260a

2000

M137699

2000

ST263

1413

M137371

1413

JUL 26 2017

DAS
6
28
9-89

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Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 9

Work Order ID: 163618

163618

Parent Item: D206-642-311BL

***D206-642-311BL ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,628.000

8

8

NAS1149D0563.J

Washer

**

JUL 15 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

108

m135774

108

ST260a

700

m137820

700

ST263

820

m137587

820

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 163618

Tuesday, July 04, 2017 11:18:30 AM

163618

Page 1

Item ID: D206-642-311BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH (Ael Blue)

Start Date: 7/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: JUL 04 2017

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control								
100	DOCUMENT CONTROL	JUL 24 2017	0.00						JUL 28 2017
DC	Memo		0.00						
Doc.Control -USB or Paperwork		Photocopy bluefile and create labels per PPP D206-642-311 CHG008							
110	Pick Kit		0.00						
110									
Packaging	Memo		0.00						
Packaging									
120	QC4- 100% Inspect kits for completeness		0.00						
120									
QC	Memo		0.03						
Quality Control									

DAS
5
9-89

United States of America
Department of Transportation - Federal Aviation Administration
Supplemental Type Certificate

Number SA00475SE

This certificate, issued to

**Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402**

certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part 27 of the Federal Aviation Regulations.

Original Product—Type Certificate Number: H2SW
Make: Bell
Model: 206, 206A, 206A-1, 206B, 206B-1, 206L, 206L-1, 206L-3, 206L-4, and 407

Description of the Type Design Change: Replacement of the original landing gear skid tubes and saddles with DART Aerospace Model D206-642 skid tubes and saddles fabricated in accordance with DART Aerospace Master Drawing List No. MDL-D206-642, Revision Q, dated March 8, 2007, or later Federal Aviation Administration (FAA) approved revision, and installed in accordance with DART Aerospace Installation Instructions No. D206-642, Revision K, dated September 25, 2006, or later FAA-approved revision. These skid tubes and saddles must be maintained in accordance with DART Aerospace Instructions for Continued Airworthiness ICA-D206-642, Revision O, dated March 7, 2007, or later FAA-accepted revision.

Limitations and Conditions: Approval of this change in type design applies to the above model rotorcraft only. This approval should not be extended to other rotorcraft of these models on which other previously approved modifications are incorporated unless it is determined by the installer that the relationship between this change and any previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of that rotorcraft. A copy of this certificate must be maintained as part of the permanent records for the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: April 22, 1997

Date reissued: October 28, 2015

Date of issuance: October 23, 1997

Date amended: April 20, 2007



By direction of the Administrator

Handwritten signature of the Manager, Seattle Aircraft Certification Office
(Signature)

for **Manager, Seattle Aircraft Certification Office**
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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